

Work Order ID 58352

May 4, 2010 8:04:55 AM

Page 1

Item ID: D3752-1

Accept

Revision ID:

Item Name: Seat Frame

Start Date: 5/04/10 Start Qty: 1.00

Required Date: 5/05/10 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3752

Rev C

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

Cut sheet to required size

BB
10/05/04

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240°F

Time IN: 4:15

Time OUT: 7:00

(10/05/04)
(10/05/05)

BB
10/05/05

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Item ID: D3752-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Frame

Start Date: 5/04/10

Start Qty: 1.00



Cust Item ID:

Required Date: 5/05/10

Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3752 and folio (FTA022) using tool DT 8997

Dwg. Rev. C

Folio Rev. C

B
10/05/05

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B
10/05/05

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

cl. *(X)*
10/05/05

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Item ID: D3752-1

Accept

Revision ID:

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Start Date: 5/04/10 Start Qty: 1.00

Required Date: 5/05/10 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



HandThermo

Memo

0.00

0.00

Hand Finishing Thermoforming

1) Trim to Finished Dimensions

150



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

160



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

tested in seat of Mark up 205 hih
Sisolos

Sisolos

(f)

BB
10/05/05
X1

BB
10/05/05

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Page 4

Item ID: D3752-1

Accept

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Start Date: 5/04/10 Start Qty: 1.00

Required Date: 5/05/10 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location *251A*

0.00



Packaging

Memo

0.00

Packaging

10-5-5

2 *10*

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/06 *AF*

W 10-5-5

Picklist Print

May 4, 2010 8:04:54 AM

Page 1

Work Order ID: 58352

Parent Item: D3752-1

Parent Item Name: Seat Frame

Comments: IPP REV: A New Issue 08.06.03 DL verified by:DD
IPP Rev. B Dwg. Update 08/07/22 DL IPP Rev. C
Dwg. Update Shorter length 08/10/28 DL IPP Rev D Add Step 105
Dry Material 10/04/21 DL

Start Date: 5/04/10

Required Date: 5/05/10

Start Qty: 1.00

Required Qty: 1.00

MLEXS.125-F60029-04

Purchased

No

100

sf

2,606.532

10.667



GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT

2606.5328

111710

64

112585

195

114032

2347.5328

BB
10/05/04

DART AEROSPACE LTD		Work Order:	58352
Description: Seat Frame		Part Number:	D3752-1
Inspection Dwg: D3752	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			
Edges and corners such as thinness, cracks and sharp edges	✓			

Measured by:	<i>BB</i>	Date:	10/05/05
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.028	Min	.073	✓			
0.035	Min	.043	✓			
0.040	Min	.058	✓			
0.075	Min	.105	✓			
0.052	Min	.084	✓			
0.021	Min	.024	✓			
0.036	Min	.054	✓			

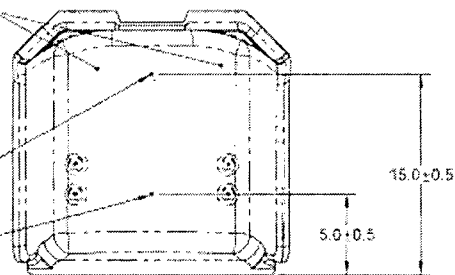
Measured by:	<i>BB</i>	Date:	10/05/05
Audited by:	<i>Sh</i>	Date:	10/05/05
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL <i>AK</i>	<i>pu</i>

ENSURE MATERIAL IN THIS AREA IS OPAQUE WITH A CONTINUOUS TEXTURE

OPTIONAL TOOLING HOLE 0.023 MIN THICKNESS AT THIS LOCATION

OPTIONAL TOOLING HOLE 0.035 MIN THICKNESS AT THIS LOCATION



0.040 MIN THICKNESS ALONG TOP EDGE

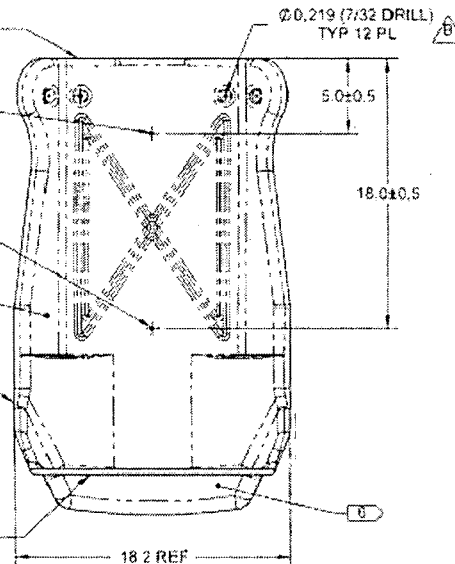
OPTIONAL TOOLING HOLE 0.075 MIN THICKNESS AT THIS LOCATION

OPTIONAL TOOLING HOLE 0.052 MIN THICKNESS AT THIS LOCATION

HEAVY HAIRCELL TEXTURE ON THIS SIDE

0.021 MIN THICKNESS IN THIS AREA (CORNER)

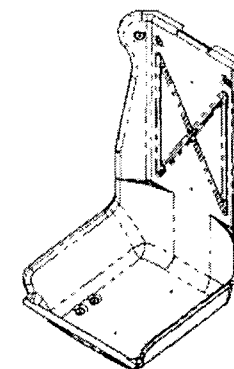
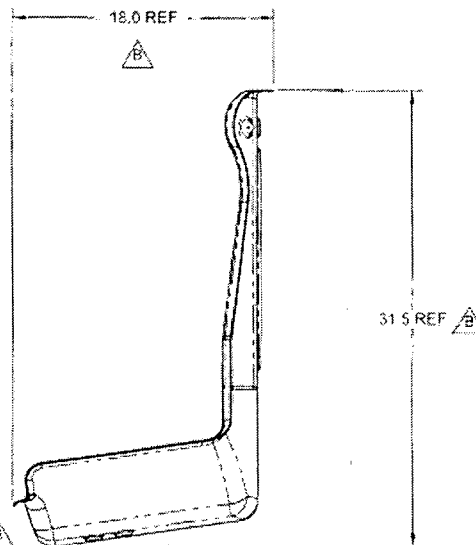
0.035 MIN THICKNESS ALONG BOTTOM EDGE



D3752-1 SEAT FRAME

NOTES:

- 1) MATERIAL: F60029 LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, GY3778 COLOR (DARK GREY) (REF DART SPEC. MLEXS.125-F60029-04).
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3752-1" & B/N "BXXXXX" USING VIBRATING STYLUS
- 7) WEIGHT: 3.0 lbs
- 8) THERMOFORM PER DT8997 AND QSI 022. ORIENT TEXTURE AS SHOWN. TRIM TO MOLD



wlo 58352

RELEASED
08/10/08

REV	DESCRIPTION	BY	DATE
C	REDUCE THICKNESS 0.040 WAS 0.050 (2N CB-1), 0.075 WAS 0.100 (CB-1), 0.052 WAS 0.040 (BB-1), 0.021 WAS 0.030 (BB-1), 0.035 WAS 0.060 (AB-1), 0.075 WAS 0.035 (DB-1), 0.035 WAS 0.050 (DB-1). SOME HOLES NOW OPTIONAL (AB-1 TO DB-1).	CP	08.10.08
B	FRONT PORTION NOW SHORTER (BB-1), 16.0 WAS 19.5 (C4-1), 31.5 WAS 20.3 (B3-1). ADD 4 HOLES FOR THICKNESS MEASUREMENT (D3-1, DB-1).	CP	08.09.06
A	NEW ISSUE	CP	09.04.75
DESIGN	<i>GP</i>	DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA DRAWING NO. D3752 TITLE SEAT FRAME SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE RELEASED FOR ANY PURPOSES OR UNDER ANY NAME OR TITLE, IN ANY FORM OR BY ANY MEANS, WITHOUT PERMISSION FROM DART AEROSPACE LTD.	
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CHECKED	<i>GP</i>		
MFG. APPR.	<i>GP</i>		
APPROVED	<i>GP</i>		
DE APPR	<i>GP</i>	DATE 08.10.08	